

303 - 250

Work Order ID 73391



Page 1

Wednesday, August 31, 2011 3:03:47 PM

Item ID: D3501-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 8/31/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/08/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3501	Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

1-TURN AS PER FOLIO FA650 & DWG D3501, □FOLIO
REV: NA □DWG REV: NA □2-DEBURR AS REQUIRED

200 φ 11/10/14

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

SD/AS

200 φ 11/10/14

120

0.00



QC8- Inspect parts - second check

Memo

0.00

B.A 11/10/17

200 φ

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73391

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Wednesday, August 31, 2011 3:03:47 PM

Item ID: D3501-1

Accept



Setup Start



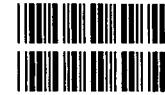
Revision ID:

Item Name: Bushing

Stop



Start Date: 8/31/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Identify as per dwg & Stock Location

ST 63

0.00

Sp 11-10-19.

Packaging

Memo

0.00

140



QC21- Final Inspection - Work Order Release

0.00

n 110/19 JF

QC

Memo

0.00

Quality Control

ME
11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, August 31, 2011 3:03:45 PM

Work Order ID: 73391



Parent Item: D3501-1



Parent Item Name: Bushing

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:A New Issue 06-05-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 		Purchased	No			100	f	124.7700	0.0791	16.65263	 15.833		11/10/14

303 Round Bar 0.750

Location	Loc Qty	Loc Code
MAT028 	124.77	
117328	36.97	
117798	9.8	
118400 	36.4	
118509	41.6	

5.938

9.896

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial- Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	73391
Description: Bushing	Part Number:	D3501-1
Inspection Dwg: D3501 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.S.</u>	Audited by:	<u>B.A.</u>	Prototype Approval:	N/A
Date:	<u>11/03/14</u>	Date:	<u>11/10/17</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	JUL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

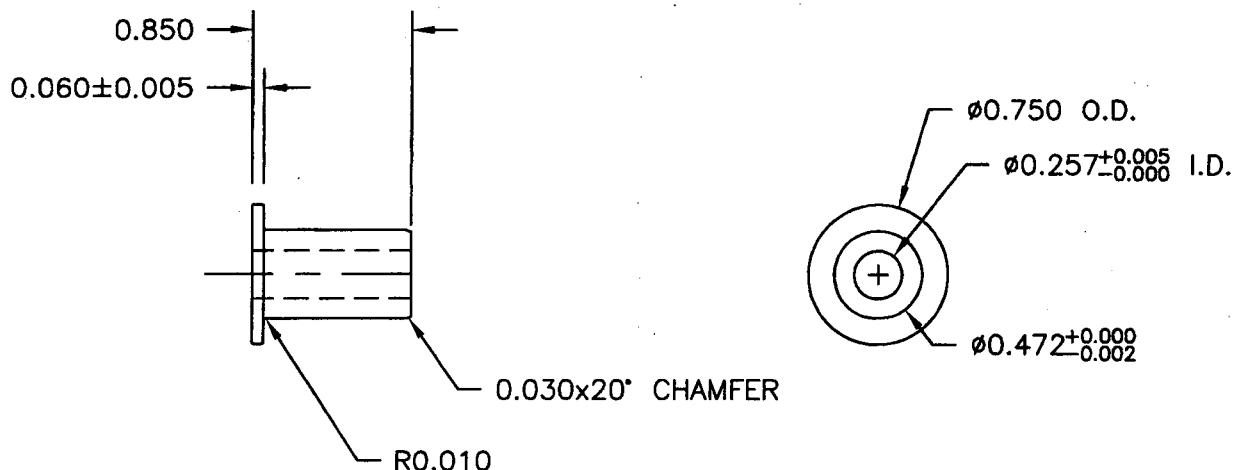
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>QP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>MM</i>	DRAWING NO. D3501	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE BUSHING	SCALE 1:1
A	06.04.18	NEW ISSUE	

**D3501-1 BUSHING**

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73391

CZ 11/08/131

RELEASED

06.08.15 MM

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Dart Aerospace Ltd

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